



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4027-041
Job Sheet 179340



Part No: D4027-041

Job Qty: 6 ea

Part Name: Hose Clamp Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/18/18

Job Tracking No:

Due Date: 6/22/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A SHEETS 1,3 IPP rev A 10.02.01 new issue Prelim EC verified by:JLM IPP Rev:B 10.05.17 as per ECN10-562 DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	6/22/18	6/22/18	0.00	0.00	Start Up Small Fab-3		SMB
100	Small Fab	6 pcs	6/22/18	6/22/18	0.00	4.59	Small Fab-5		SMB
110	QC	6 pcs	6/22/18	6/22/18	0.00	0.00	QC5		38
120	Packaging	6 pcs	6/22/18	6/22/18	0.00	0.00	Packaging3-2	57245	JUN 19 2018
130	QC21-SA	6 Ea	6/22/18	6/22/18	0.00	0.00	QC21		DAG 21 180620

Part Op 100 - Drill hole and assemble as per dwg notes

Descriptions: 110 - QC5- Inspect part completeness to step on W/O

120 - Identify as per dwg & Stock Location: _____

130 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN743-13	Bracket	6 pcs (1 ea)	90-Start up Operation	5019324
D4027-1	Hose Clamp	6 Ea (1 ea)	90-Start up Operation	1105820
D4027-7	Rubber Cushion 5.30" Long	6 Ea (1 ea)	90-Start up Operation	5058105
MS21042L09	Nut(Not A Good Number)	6 Ea (1 ea)	90-Start up Operation	5049834
MS24693-S28	Screw	6 Ea (1 ea)	90-Start up Operation	F8170
NAS1149DN632J	Washer	6 pcs (1 ea)	90-Start up Operation	5024482

1300L m138715

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN743-13	6	39	0
	D4027-1	6	6	0
	D4027-5	6	6	0
	MS21042L09	6	0	0
	MS24693-S28	6	47	0
	NAS1149DN632J	6	231	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



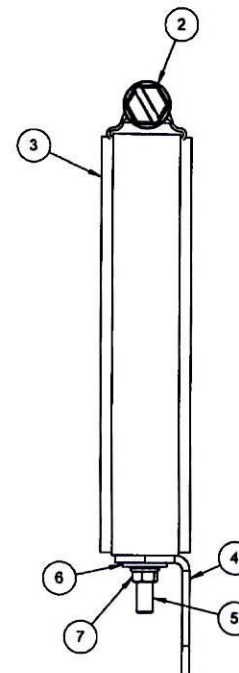
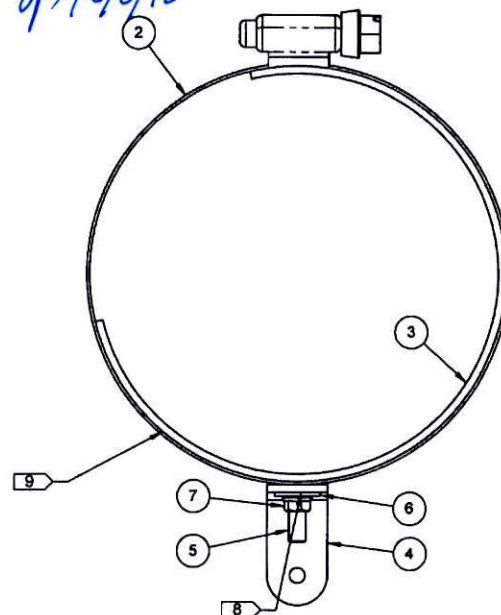
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐							

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4027-041	VENT CLAMP ASSEMBLY	JCA-M47-2-20
2	1	D4027-1	HOSE CLAMP	
3	1	D4027-5	RUBBER CUSHION	
4	1	D4027-9	BRACKET, SUPPORT ANGLE	
5	1	MS24693S28	SCREW	
6	1	NAS1149DN632J	WASHER	
7	1	MS21042L06	NUT	



D4027-041 VENT CLAMP ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4027-041" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.08 lbs
- 8) ATTACH D4027-9 BRACKET USING MS24693S28 SCREW, MS21042L06 NUT AND NAS1149DN632F WASHER
- 9) GLUE D4027-5 RUBBER CUSHION TO D4027-1 CLAMP USING 3M CONTACT CEMENT IN POSITION AS SHOWN

RELEASED
2010-05-05

A	NEW ISSUE	BY	10.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.04.16		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4027** REV. A
SHEET 1 OF 7
TITLE **CLAMP** SCALE NTS

COPYRIGHT © 2010 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD



Container No: S081989



Part: D4027-041

Job No: 179340

Serial No/Batch: S081989

Revision:

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/18/18